

Date: Wednesday, 7/11/2007 2:47:40 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LONG STEP ASSEMBLY HIGH SKID LH

Job Number : 33482

Estimate Number : 10270

P.O. Number : NIA

This Issue : 7/11/2007

S.O. No. : NIA

Prsht Rev. : NC

First Issue : NIA

Type : LARGE FAB ASSY

Previous Run : 33377

Part Number : D350591311

Drawing Number : D3272 REV B

Project Number : N/A

Drawing Revision : B

Material : NIA

Due Date : 8/10/2007

Qty: 10 Unit Each

Written By :

Checked & Approved By :

Comment :

Est Rev A 04.03.22 New issue KJ/RF

Est Rev B 07-06-09 Added D3272-1 JLM

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

2.0

D32721

STEP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: 33372

3.0

D30671

End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 332836

4.0

D32191

Support

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support 333428

Date: Wednesday, 11/11/2007 2:41:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

50

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719; weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

MIC 3294
MIC 4721

3-Grind End Plate flush

Q.M.

07-07-28

10

60

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

70

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M. 07-07-30

10

90

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

100

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B32032

Q.M. 07-08-09

10

110

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B338572
B33100158

Q.M. 07-08-14

10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

MS20600AD4W4

Rivets



Comment: Qty: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet 362104715 MIC394715

Q.M. 07-08-09 10

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

Leave one rivet out until welding is complete.

Q.M. 07-08-09 10

14.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q.M. 07-08-14 10

15.0

D30671

End Plate



Comment: Qty: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 330225

B32836

Q.M. 07-08-14 10

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

AVR Aluminum Rod MIC3794

4-Grind End Plate flush

Q.M. 07-08-20

5-Install last rivet as per Dwg.

Q.M. 07-08-20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M07/08/20

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50 07/08/20 (X10L)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
touch up alodine

BR / FES

07-08-22

(10)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/BR

07-08-22

(10)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M104942

M-L 07/08/23

(10X)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

7/8/22 SP

(10X)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

1330993

50

7/8/20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

1331831

SP

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

1332992

SP

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

1330996

SP

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

1331838

SP

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

14104021

SP

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

14104021

7/8/13 SP

Process Sheet

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M104625

SP

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M104385

SP

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M104215

SP

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M104156

SP

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M104936

7/8/13 SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID LH

Job Number: 33482

Part Number: D350591311

Job Number



Seq. #

Machine Or Operation:

Description :

35.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

1107552

SP

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

1104118

7/8/13

SP

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

* Placed kit in individual bags.

2070823

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location:

7/8/24

SP

①

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Done 7/8/24

In Completion



u 7-8-24



DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

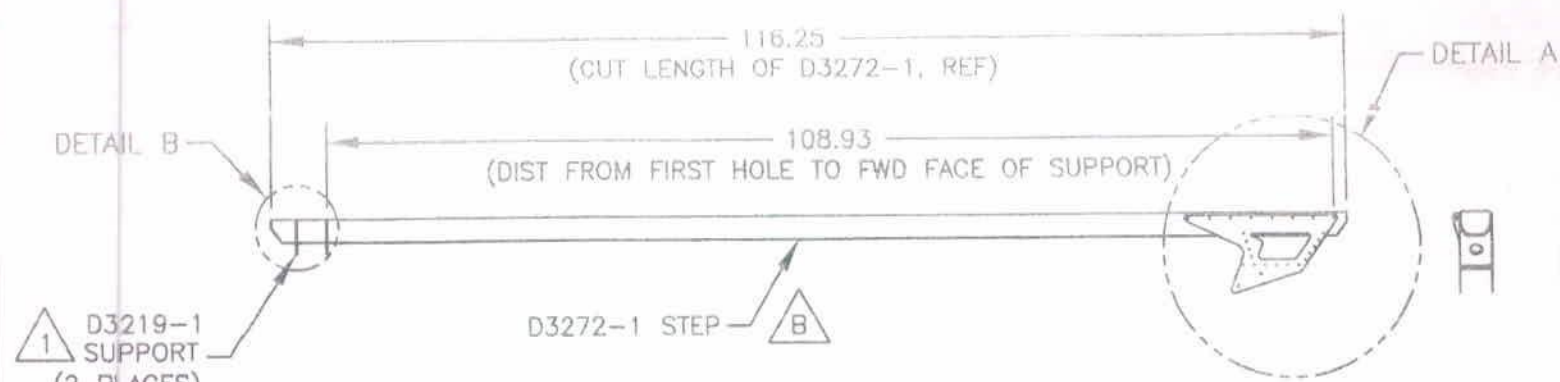
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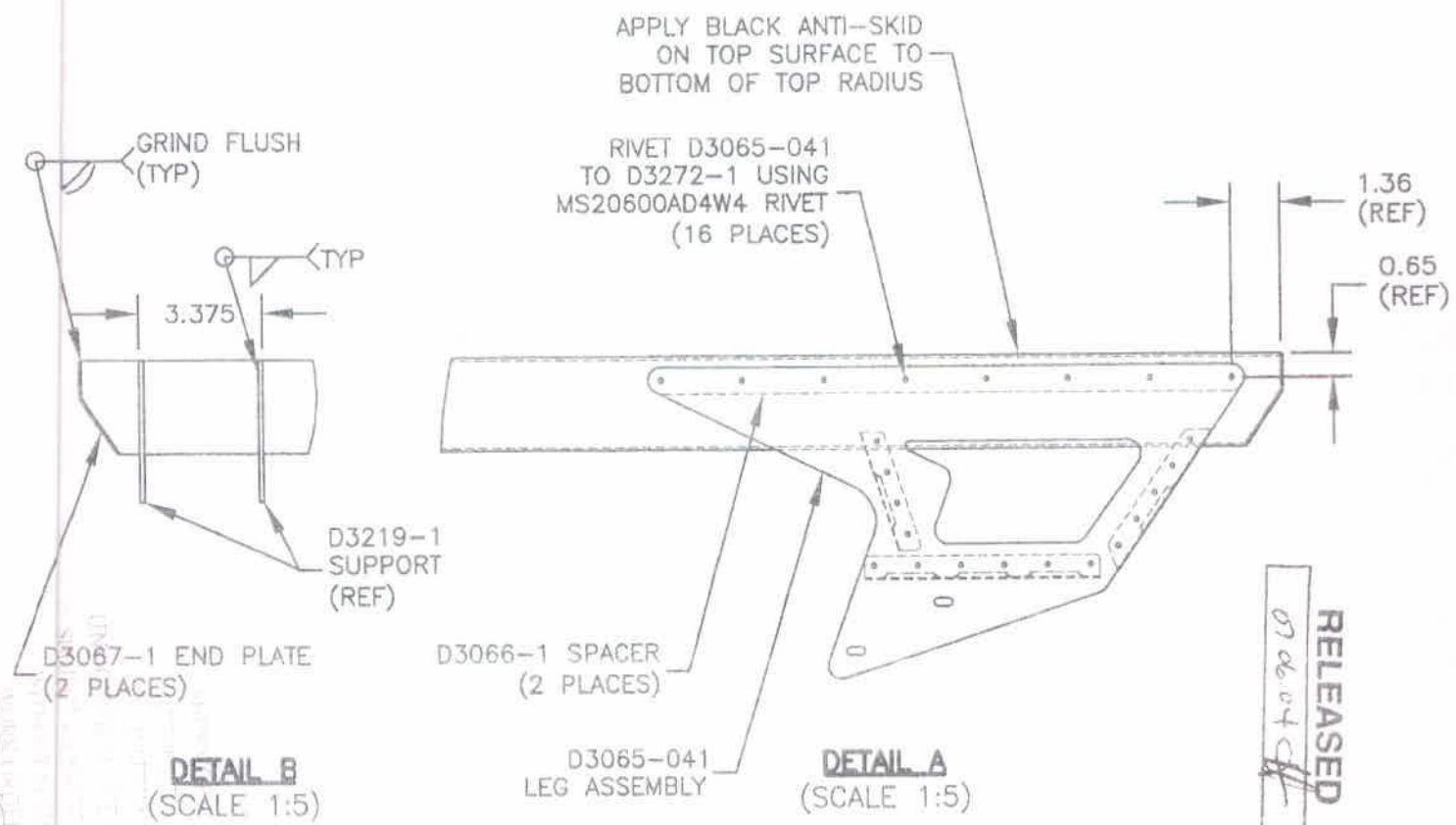
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DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD
CHECKED	CE	APPROVED	AP	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

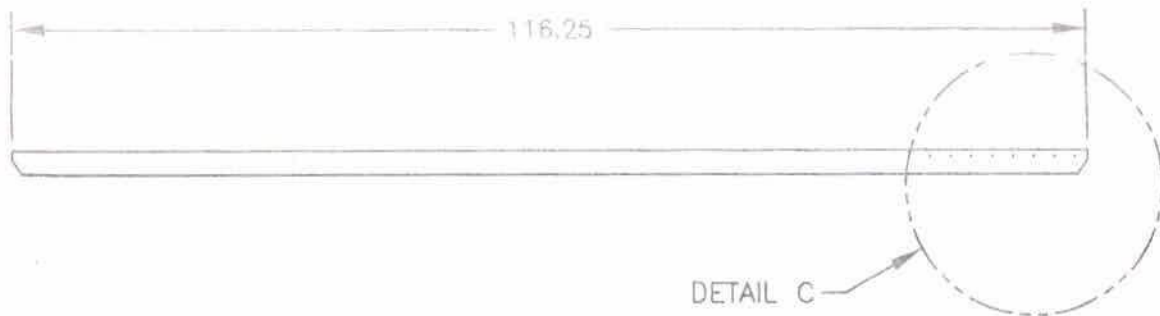


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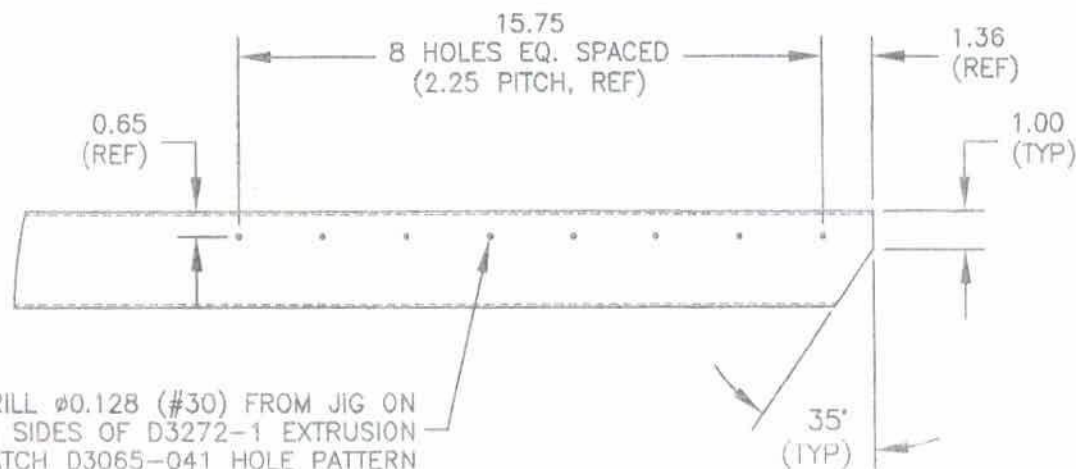
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DART

DESIGN	<i>ap</i>	DRAWN BY	<i>js</i>	DART AEROSPACE LTD	REV. B
CHECKED	<i>CE</i>	APPROVED	<i>js</i>	HAWKESBURY, ONTARIO, CANADA	
DATE	07.05.18	DRAWING NO.	D3272	SHEET 3 OF 3	SCALE
		TITLE	STEP ASSEMBLY, HI LONG		1:20



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

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